Each

Dart Aerospace Ltd. Tuesday, 10/2/2007 1:20:21 PM Kim Johnston **Process Sheet Drawing Name** : BUSHING : CU-DAR001 Dart Helicopters Services Customer Job Number : 34948 : 10725 **Estimate Number** : NA : D2652 Part Number P.O. Number D2652 REV A : 10/2/2007 **Drawing Number** This Issue : N/A Prsht Rev. Project Number : MACHINED PARTS **Drawing Revision** First Issue : 34893 **Material** Previous Run : 10/30/2007 Due Date 200 Um: Written By Checked & Approved By : Est Rev:B 02.06.13 Now machined in house. NG Comment Additional Product Job Number: Description: Machine Or Operation: Seq. #: 303 Round Bar 0.500" 1.0 M303R0500 Comment: Qty.: 11.5500 f(s) 0.0578 f(s)/Unit Total: Material:303 ss .500" Round Bar (M303R0500) Batch: M 105 839 HARDINGE HARDINGE CNC LATHE SMALL 2.0 Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA250 & Dwg D2652 2-Deburr QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0

5.0

Comment: SECOND CHECK

PACKAGING 1

Comment: PACKAGING RESOURCE #1 Identify and Stock

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Dart Aerospace Ltd

W/O: WORK ORDER CHANGES									
DATE	STEP	TEP PROCEDURE CHANGE		PROCEDURE CHANGE By	Ву	By Date		Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:	PAR #: Fault Category:	NCR: Yes No DQA: Date	61/01/50:
		QA: N/C Closed: Date	:
NCR:	WORK ORDER NON-CONFOR	MANCE (NCR)	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC	Cription of NC Corrective Action Section B			Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Date:

Tuesday, 10/2/2007 1:20:21 PM

Üser:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 34948

Part Number: D2652

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



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Dart Aerospace Ltd

W/O:		WORK ORDER CH	WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	_ Date: _	·	

QA: N/C Closed: ____ Date: __

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC	Corrective Action Section B		Verification	A		
DATE	STEP	Section A	Initial Action Description Sign & Chief Eng Date		Section C	Approval Chief Eng	Approval QC Inspecto	
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34948
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Х	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.600	+/-0.010					
0.060	+/-0.005					
Ø0.305	-0.002/+0.000					
Ø0.191	+0.005/-0.000					
Ø0.500	+/-0.010					
0.030 x 20°	+/-0.010					
R0.010	+0.010/-0.000					
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Measured by:	Audited by:	Prototype Approval:	V/A
Date:	Date:	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.12.12	New Issue	KJ/RF	- 4

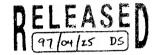
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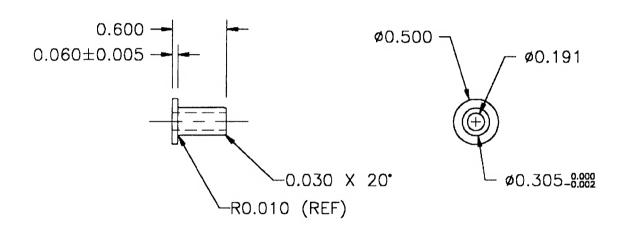
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DESIGN	DRAWN BY	DART AEROSPACE U	
CHECKED	APPROVED	DRAWING NO.	REV. A
BW	1010g	D2652	SHEET 1 OF 1
DATE		TITLE	SCALE
97:03:25		BUSHING	1:1





MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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ENGINEERING

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WORK ORDER

DART AEROSPACE LTD	Work Order:	34348
Description: Bushing		
Inspection Dwg: D2652 Rev: A	Part Number:	D2652
, surg. D2002 Rev. A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype						
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.600	+/-0.010	0.602				
0.060	+/-0.005	0.060	V			
Ø0.305	-0.002/+0.000	0.3045	1	 		
Ø0.191	+0.005/-0.000	0,1935		 		
Ø0.500	+/-0.010	0.4985	V			
0.030 x 20°	+/-0.010	,03×20°				
R0.010	+0.010/-0.000	0.015				
	-	0.019				
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Measured by:	Audited by:		
	Addited by:	Prototype Approval:	N/A
Date: 07/10/10	Date: 07760/10	Date:	
Pov Det	19 0/10//	Date.	

Rev Date	Change		
A 03.12.12		Revised by	Approved
		KJ/RF	. 14